

Blue Ship Sept 28  
Work Order ID 61959

Monday, September 13, 2010 10:08:14 AM

Page 1

Item ID: D206-667-203BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft, Blue

Start Date: 9/14/2010 Start Qty: 1.00

Required Date: 9/24/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-667-243	C

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels as per PPP D206-667-203 CHG003

0.00

0.00

5/10/09/28

10-9-28

110



CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

Memo

Bend tube as per Dwg D206-667-243 using CNC bender program D206-667-203

0.00

0.00

IX 10-09-15

120



QC

Quality Control

QC15- Crosstube Dimensional Check

Memo

0.00

0.00

8/10/09/15

LI

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Crosstubes

Crosstubes

**Memo**

0.00

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 and drill table DT8577 and tower holes #6 as per QSI0010 and as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243 Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243 Inside of Cuff(Donot engrave on outside of tube)

10 -Deburr & Inspect for surface damage. Repair damage within limits as per

SAD/MP  
10-09-16

DP 10-9-20

W/O:		WORK ORDER CHANGES					
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Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampDwg  
D206-667-243

140



Crosstubes Chemical Conversion

0.00

DP

10-9-20

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

150



QC3- Inspect Part Finish

0.00

8/10/09/20

QC

Memo

0.00

Quality Control

160



QC5- Inspect part completeness to step on W/O

0.00

8/10/09/20

QC

Memo

0.00

Quality Control

FLO

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
	SprayPaint					<u>m</u>	<u>10</u>	<u>09</u>	<u>22</u> (1)
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube DELFLEET BLUE B <u>113171</u> CLEAR DELFLEET B <u>110896</u>  PRIME: Start Time: <u>9:00</u> Finish Time: <u>10:00</u>  PAINT: Start Time: <u>2:00</u> Finish Time: <u>3:00</u>								
210									
	QC14- Inspect Spray Paint	0.00							
QC	Memo	0.00							
Quality Control	Wrap in plastic bag to protect from scratches								
						<u>RT</u>	<u>10-09-23</u>		(Y1)

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Crosstubes	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install nut plates as per Dwg D206-667-243.								
230  Crosstubes	Skidtubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (3) top holes should be facing up. A/R Magnobond 6398 : 114158 exp: 01/2011								
	2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb ml 10.09.27								

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/09/23

0.00

Memo

⑩

250



Packaging

Packaging

Pick Kit

0.00

0.00

Memo

6/10/09/25 ⑩

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/09/26

0.00

Memo

⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 9/14/2010 Start Qty: 1.00



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Required Date: 9/24/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-667-203								
	Location: <u>118</u>								
	PPP Rev: <u>18</u>								
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/9/08 SP

10/09/28 MF

MF

10-9-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, September 13, 2010 10:08:13 AM

Page 1

Work Order ID: 61959

Parent Item: D206-667-203BL

Parent Item Name: Crosstube Aft, Blue



Start Date: 9/14/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-10A 		Purchased	No				Each	255.0000	10	10			
-------------	--	-----------	----	--	--	--	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST337	255	
114752	5	
115108	100	M115108
115429	50	
115589	100	

AN5-32A 		Purchased	No				Each	240.0000	4	4			
-------------	--	-----------	----	--	--	--	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST340	240	
113121	4	
114056	26	M114056
114405	50	
115016	50	
115108	50	
115589	60	

AN5-34A 		Purchased	No				Each	72.0000	4	4			
-------------	--	-----------	----	--	--	--	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST340	72	
113149	22	M113149
113226	50	

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Crosstube Aft, Blue

Start Date: 9/14/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased

No

Each

34.0000

18

18



Washer



*MB 11-17-12*

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D206-667-203TRN

Manufactured

No

Each

4.0000

1

1



Crosstube Turning Detail



*MB 10-09-14*

Location

Loc Qty

Loc Code

LG

4

61446

1

61447

1

61448

1

61449

1

D2873-043

Manufactured

No

Each

32.0000

2

2



Nut Plate Assembly



*MB 10-09-23*

Location

Loc Qty

Loc Code

LG

12

57337

12

ST

20

60981

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 9/14/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

D2873-045

Manufactured No

Each

28.0000

2

2



Nut Plate Assembly



MA 10-09-23

Location

Loc Qty

Loc Code

LG

28

~~57336~~

8

60982

20

D2892-1

Manufactured No

Each

44.0000

2

2



Support



MA 10-09-23

Location

Loc Qty

Loc Code

LG

44

41986

12

42785

20

53124

8

~~55787~~ X1

1

~~61631~~ X1

3

ATTN:BLUE

D3595-063-450

Manufactured No

Each

131.6590

4

4



RUBBER CUSHION



MA 10-09-23

Location

Loc Qty

Loc Code

LG

131.6589737

53775

5.97897368

58161

3.56

59580

10.12

~~60983~~

33

61465

79

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Shop Packet Print

Page 3

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Start Date: 9/14/2010

Required Date: 9/24/2010

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W10

Purchased

No

Each

116.0000

14

14



RIVET



*ml 10-09-23*

## Location

## Loc Qty

## Loc Code

LG051

102

114245

2

115405

100

ST322

14

113220

14

MS21042L5

Purchased

No

Each

1,105.000

4

4



Nut



*10/5/28*

## Location

## Loc Qty

## Loc Code

ST139

105

114813

105

ST300

1000

115156

500

115594

500

MS21920-22

Purchased

No

Each

86.0000

4

4



Clamp(per MIL-DTL-8783C)



*ml 10-09-23*

## Location

## Loc Qty

## Loc Code

LG

86

114077

86

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Shop Packet Print

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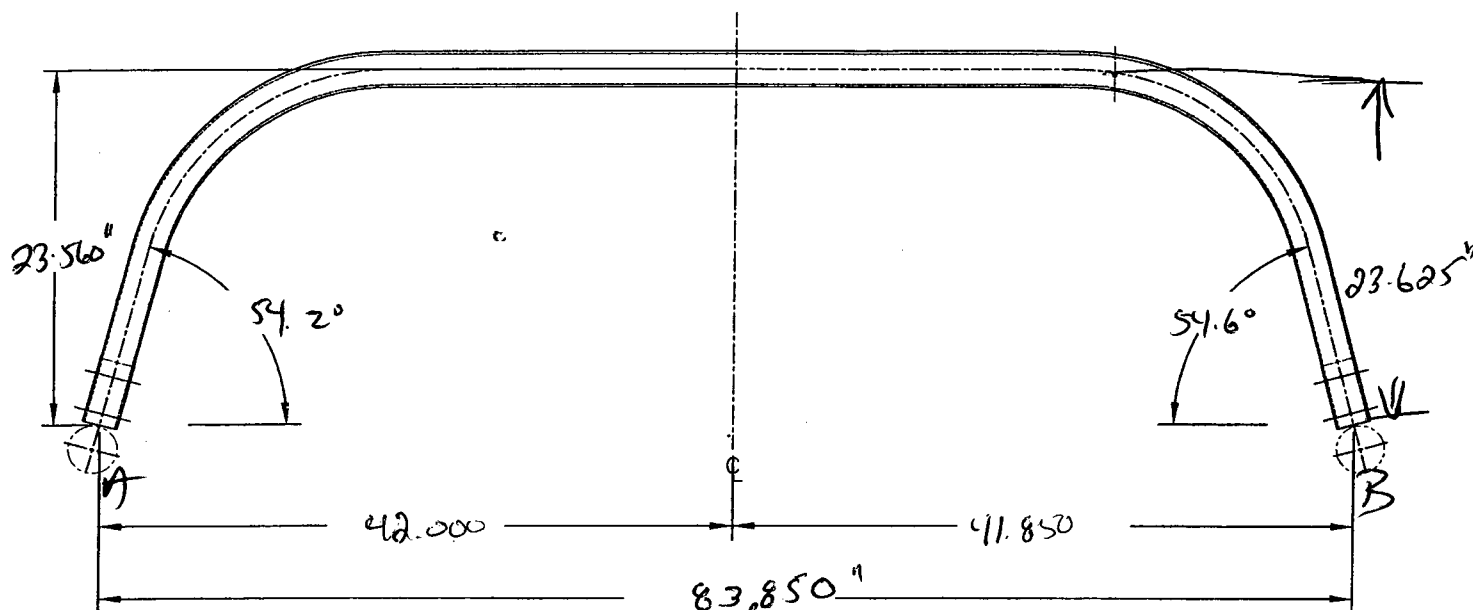
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 61989
<b>Description:</b> Crosstube High Aft (206L)		<b>Part Number:</b> D206-667-203
<b>Inspection Dwg:</b> D206-667-243 <b>Rev:</b> C		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.1



Comments

QC15 Inspection	S
Date	10/25/15

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.11.17	Dwg Rev updated	KJ	
C	09.12.14	Dimensions update per Dwg Rev C	KJ	

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	Qty	Part Number	Description
	-243		
1	X	D206-667-243	CROSSTUBE ASSEMBLY (206L HIGH AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-243" AND BATCH NUMBER ON  
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 21.9 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER  
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

**RELEASED**  
06/11/10

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-450 WAS D2856-400-773 (ZN D8-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN 4-3, C5-3, D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-243	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

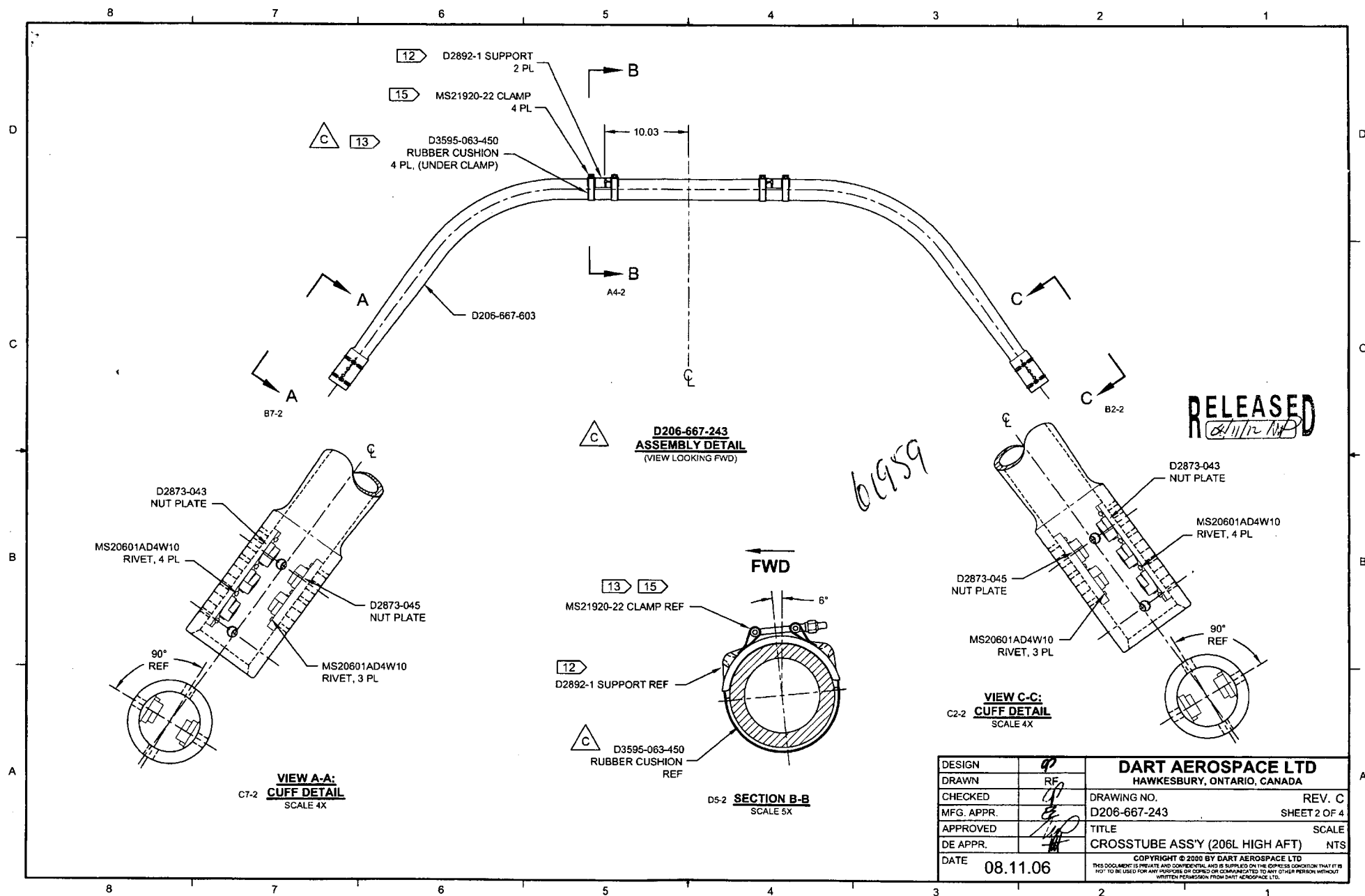
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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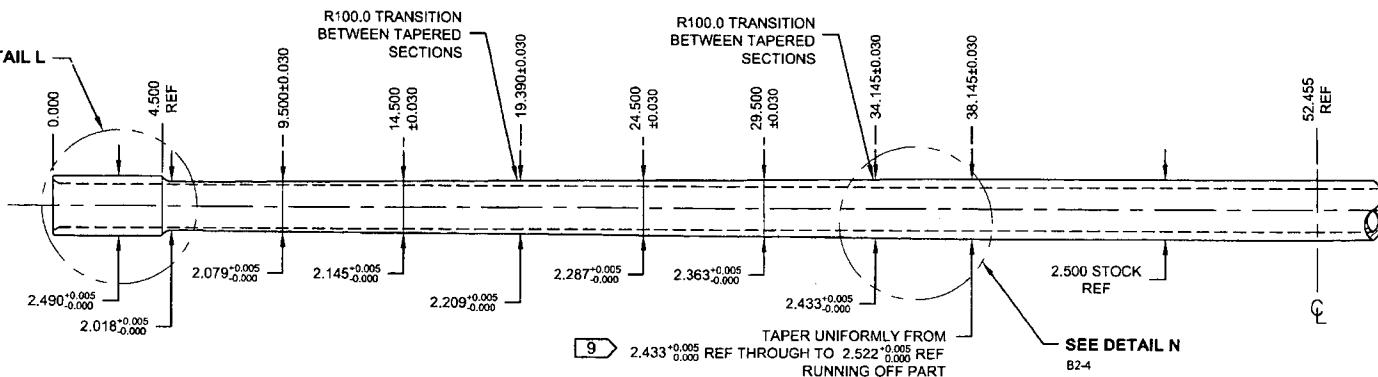
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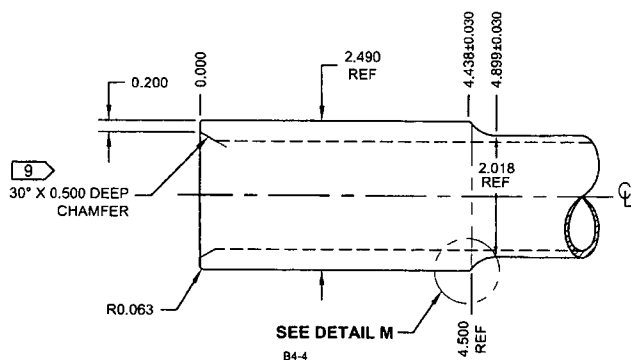
**NOTE:** Date & initial all entries



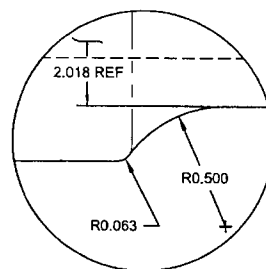
SEE DETAIL L  
B7-4



**TURNING DETAIL**

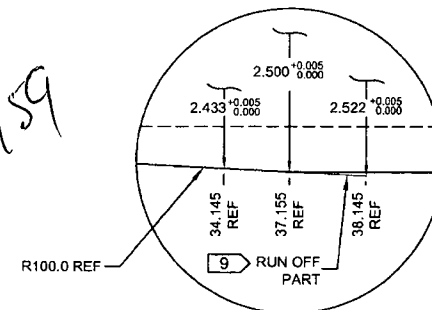


**DETAIL L: CROSSTUBE CUFF**  
NOT TO SCALE



**DETAIL M: CUFF TRANSITION**  
NOT TO SCALE

66459



**DETAIL N: TAPER RUN-OFF**  
NOT TO SCALE

**RELEASED**  
08/11/06

DESIGN	9	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED		D206-667-243	SHEET 4 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		CROSSTUBE ASS'Y (206L HIGH AFT)	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# LIQUID PENETRANT TEST REPORT

P- 15193

PAGE 1 OF 1

CLIENT DACT Aerospace DATE SEPT-21-2010 TIME AM ☒ PM ☐  
ATTENTION LINDA / CHARTER ACUREN JOB No. 188-10-0889  
ADDRESS 1270 ABELEEN ST. POWO No. 12615  
HAWKES BURY, ON. WORK LOCATION HAWKES BURY PLANT  
PROJECT F. P. I. (10) ON CROSS TUBES ACCEPTANCE STD. ASTM 1417 REV./DATE 2007  
ITEM(S) EXAMINED (7) MACHINED PARTS

JOB DESCRIPTION WET FLUORESCENT LIQUID PENETRANT 2 + ALUMINUM PROCEDURE No. LT0002 REV./DATE LT0002 TECHNIQUE No. LT0002 REV./DATE 2007  
PART No. — MATERIAL STAINLESS STEEL THICKNESS  
SCOPE INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE

TEST DETAILS  
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
PENETRANT ZL 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H2O MINIMUM DRY TIME 5 MIN. OTHER LA3, NO  
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE OCT 17 2010  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE  
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL  
7 SLEEVE'S → W.O. 62188 ✓  
1 CROSS TUBE → W.O. 62298 ✓  
1 CROSS TUBE → W.O. 62299 ✓  
1 CROSS TUBE → W.O. 61418 ✓  
1 CROSS TUBE → W.O. 61417 ✓  
1 CROSS TUBE → W.O. 61959 ✓  
1 CROSS TUBE → W.O. 61958 ✓  
1 CROSS TUBE → W.O. 61852 ✓  
1 CROSS TUBE → W.O. 61853 ✓  
1 CROSS TUBE → W.O. 61507 ✓  
1 CROSS TUBE → W.O. 61508 ✓  
INDICATIONS ON CROSSTUBES  
W.O. #'S → 61852, 61853.  
10-09-22

Scope of Services  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.  
Standard of Care  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES  
CLIENT REPRESENTATIVE Eric Downing DTR # EG3391  
TECHNICIAN (SIGNATURE): Mike / J. Hester REPORT REVIEWED BY:  
NAME (PRINT): Mike / J. Hester NAME INITIALS  
1<sup>ST</sup> TECHNICIAN 2<sup>ND</sup> TECHNICIAN  
CGSB LEVEL II SNT LEVEL — CGSB LEVEL — SNT LEVEL —  
CGSB REG. NO. 6606 CGSB REG. NO. —